

Work Order ID 50484

July 10, 2009 2:34:52 PM



Page 1

Item ID: D3959-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel, Aft Center

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3959

A-PROTO 09.06.17

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/14 (X1)

M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA056 using tool DT9072
Dwg Rev: A
Folio Rev: A

BB 09/07/14 (X1)

Work Order ID 50484



Page 2

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Item ID: D3959-1K1V

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel, Aft Center

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

BB 09/07/14 (X1)

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

DL 09/07/15 (X1)

QC

Memo

0.00

Quality Control

140

Hand thermo

0.00

DL 09/07/15 (X1)

Hand thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

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Item ID: D3959-1KIV

Accept



Setup Start



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Stop



Item Name: Vertical Tunnel, Aft Center

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
Quality Control	Complete FAI document								

Dr. 09/07/15 (x1)

160	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
Quality Control									

PH 09.07.20

ENGINEERING
APPROVAL

170	Identify as per dwg & Stock Location: _____	0.00							
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Packaging	Memo	0.00							
Packaging									

} Eng's testing
PH 09.07.20

Work Order ID 50484

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Item ID: D3959-1K1V

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel, Aft Center

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11.09.01.20 Prototype**BS. 24-07-09*

Picklist Print

Page 1

July 10, 2009 2:34:51 PM

Work Order ID: 50484



Parent Item: D3959-1KIVRevA-PROTO



Parent Item Name: Vertical Tunnel, Aft Center

Start Date: 07/13/2009

Required Date: 07/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	6.7290			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703
BB 09/07/14

DART AEROSPACE LTD	Work Order: 50484
Description:	Part Number: D3951-1/KIV
Inspection Dwg: D3959-1 Rev: A PRATO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

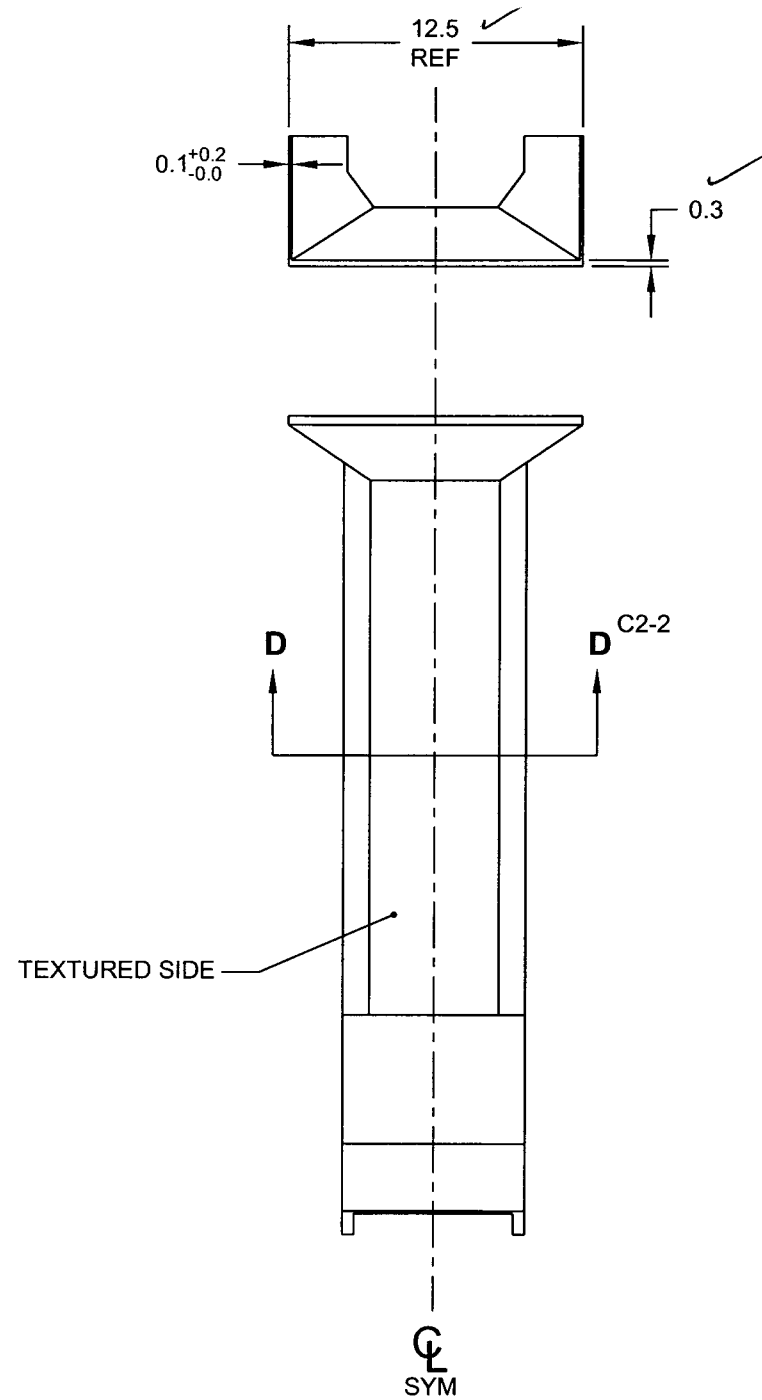
Measured by: BB-	Date: 09/07/16
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TRIMMING SECTION

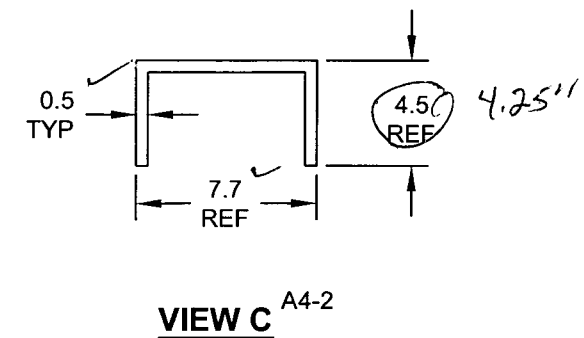
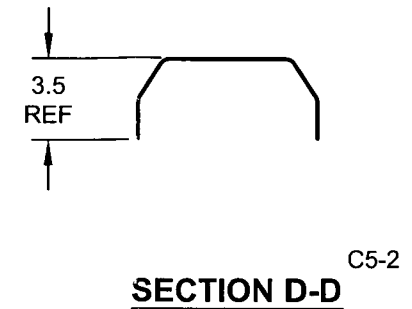
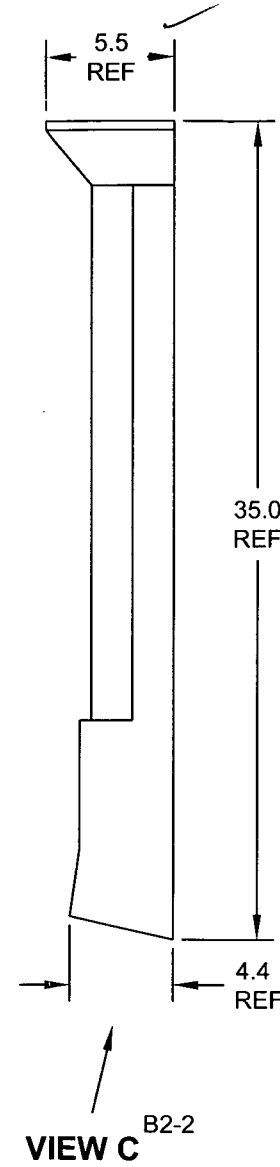
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	±.100	0.312"	✓			
12.5"	Ref	12.625"	✓			
5.5"	Ref	5.5"	✓			
35.0"	Ref	35.0"	✓			
0.5"	±.100	0.52524"	✓			
76 7.7"	Ref	7.7"	✓			
4.445	Ref	4.4425"	✓			
0.030 0.035	MIN	0.03040	✓			

Measured by: D. Hogue	Date: 09/07/15
Audited by: RJ	Date: 09-02-17
Prototype Approval: RJ	Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3959-1 VERTICAL TUNNEL, AFT CENTER

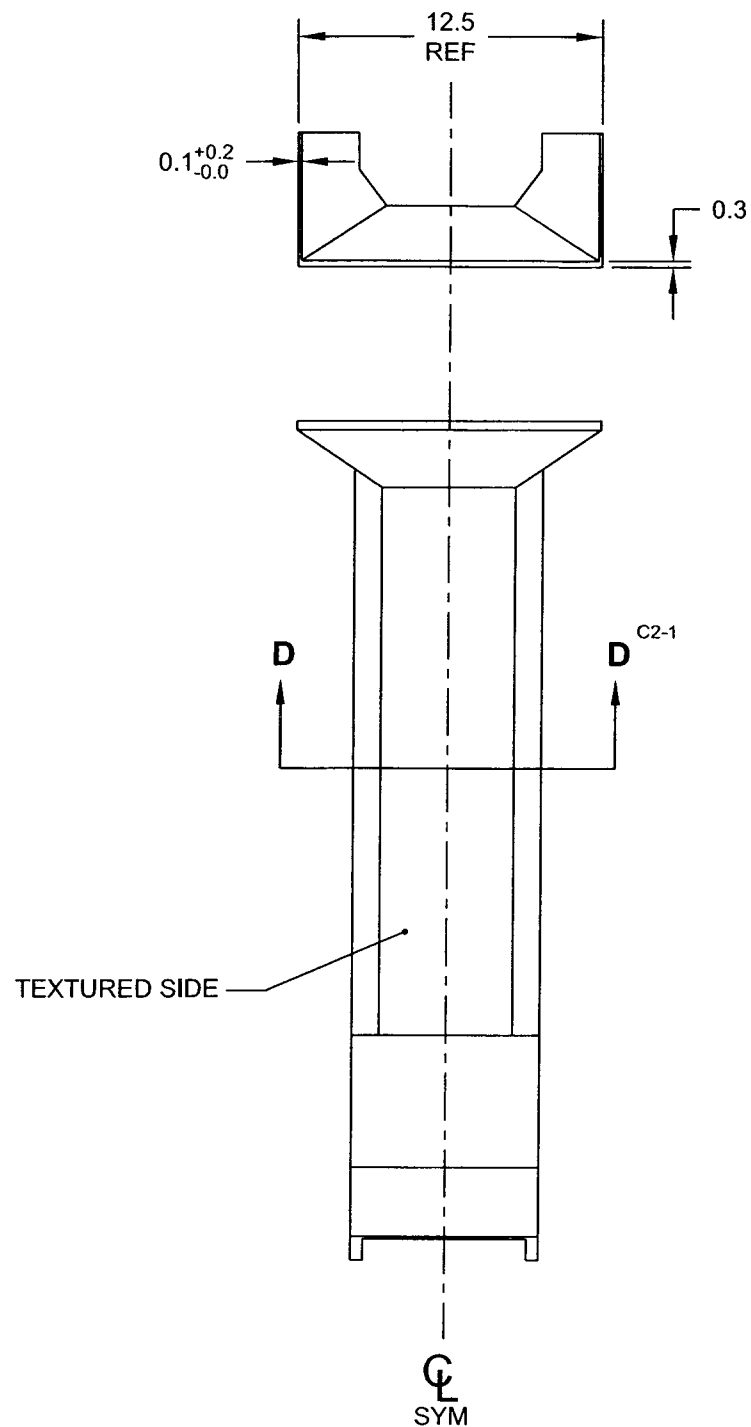


PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-07 *PS*

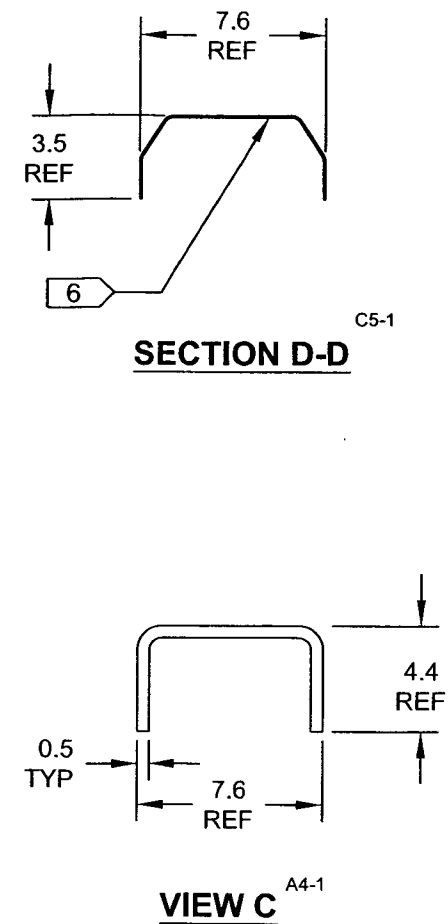
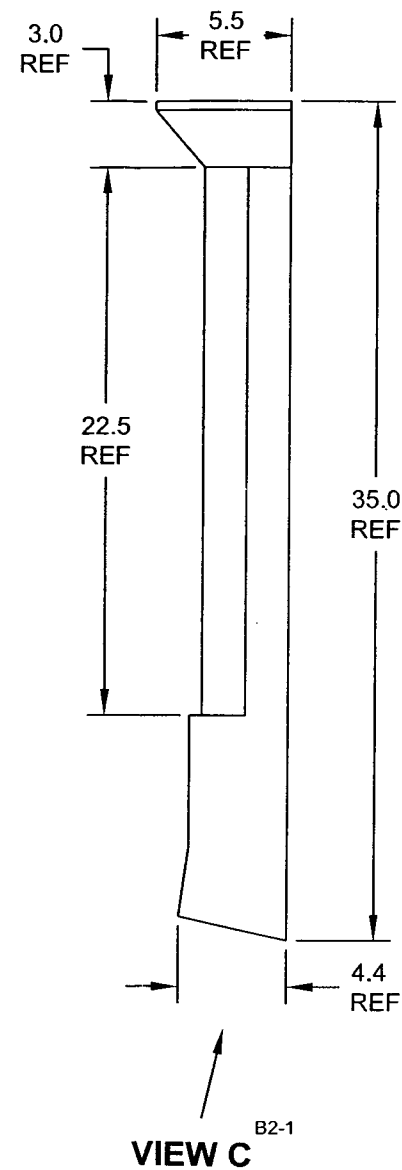
- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3959-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3959-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3959	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (206 L3/L4)	NTS
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D3959-1 VERTICAL TUNNEL, AFT CENTER



- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: SEE -041
 - 8) TOOLING: THERMOFORM PER MOLD DT9332-A PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3959-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3959-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3959	SHEET 1 OF 1
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DE APPR.		VERTICAL TUNNEL (206 L3/L4)	NTS
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